

Work Order ID 54756

December 21, 2009 9:04:43 AM

Page 1

Item ID: D3235-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Mounting Lug

Start Date: 12/21/09 Start Qty: 60.00

Cust Item ID:

Required Date: 12/31/09 Req'd Qty: 60.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3235

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.820" Batch: 44529

OK 09/12/30

72 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA369 and Dwg D3235-1 Identify as D3235-1 Deburr

OK 10/01/08

72 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

OK 10/01/08

72 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54756

December 21, 2009 9:04:43 AM

Page 2

Item ID: D3235-1

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Revision ID:

Item Name: Mounting Lug

Start Date: 12/21/09 Start Qty: 60.00

Required Date: 12/31/09 Req'd Qty: 60.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Signature
10/01/09

72

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BR 10-01-11

72

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Signature
10/01/11

Signature

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 54756

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Item ID:	D3235-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Mounting Lug				Stop	
Start Date:	12/21/09	Start Qty: 60.00		Cust Item ID:		
Required Date:	12/31/09	Req'd Qty: 60.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>1113170</i> Memo START TIME: <i>11:00AM</i> OVEN TEMPERATURE: <i>11:30pm</i> FINISH TIME: <i>320°F</i>	0.00 0.00				<i>⇒ 10-01-12</i>	<i>(X72) Ø</i>		
170  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>10-01-12</i>	<i>(72)</i>		
180  Packaging Packaging	Identify as per dwg & Stock Location: <i>471</i> Memo	0.00 0.00				<i>10-1-14</i>	<i>(72x) SP</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54756

December 21, 2009 9:04:48 AM

Page 4

Item ID: D3235-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Mounting Lug

Start Date: 12/21/09 Start Qty: 60.00

Cust Item ID:

Required Date: 12/31/09 Req'd Qty: 60.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/15
ME 10-1-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 21, 2009 9:04:42 AM

Page 1

Work Order ID: 54756

Parent Item: D3235-1

Parent Item Name: Mounting Lug

Comments:

Start Date: 12/21/09

Required Date: 12/31/09

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3235-1P		Purchased	No			100	Each	0.0000	60.0000			
lug												
D2423		Manufactured	No			110	f	621.0747	4.3137			
Lug Extrusion												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

621.0747379

43722

175.629406

44529

22.39

45800

423.055332

5.1137" ~~5.1137"~~ mf 09/12/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	54756
Description: Mounting Lug		Part Number:	D3235-1
Inspection Dwg: D3235	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010	4.450	✓			
0.306	+/-0.010	.307	✓			
1.85	+/-0.030	1.840	✓			
R1.20	+/-0.010	1.200	✓			
R0.125	+/-0.010	R.125	✓			
0.400	+/-0.010	.403	✓			
0.735	+/-0.030	.727	✓			
Ø0.505	+0.005/-0.000	.507	✓			
R0.38	+/-0.030	.38	✓			
3.700	+/-0.005	3.706	✓			
0.375	+/-0.010	.375	✓			
0.750	+/-0.010	.758	✓			
Ø0.257	+0.005/-0.000	.259	✓			
R0.380	+/-0.030	.380	✓			

Measured by: SB	Audited by: DJT	Prototype Approval:	N/A
Date: 10/01/06	Date: 10/01/09	Date:	N/A

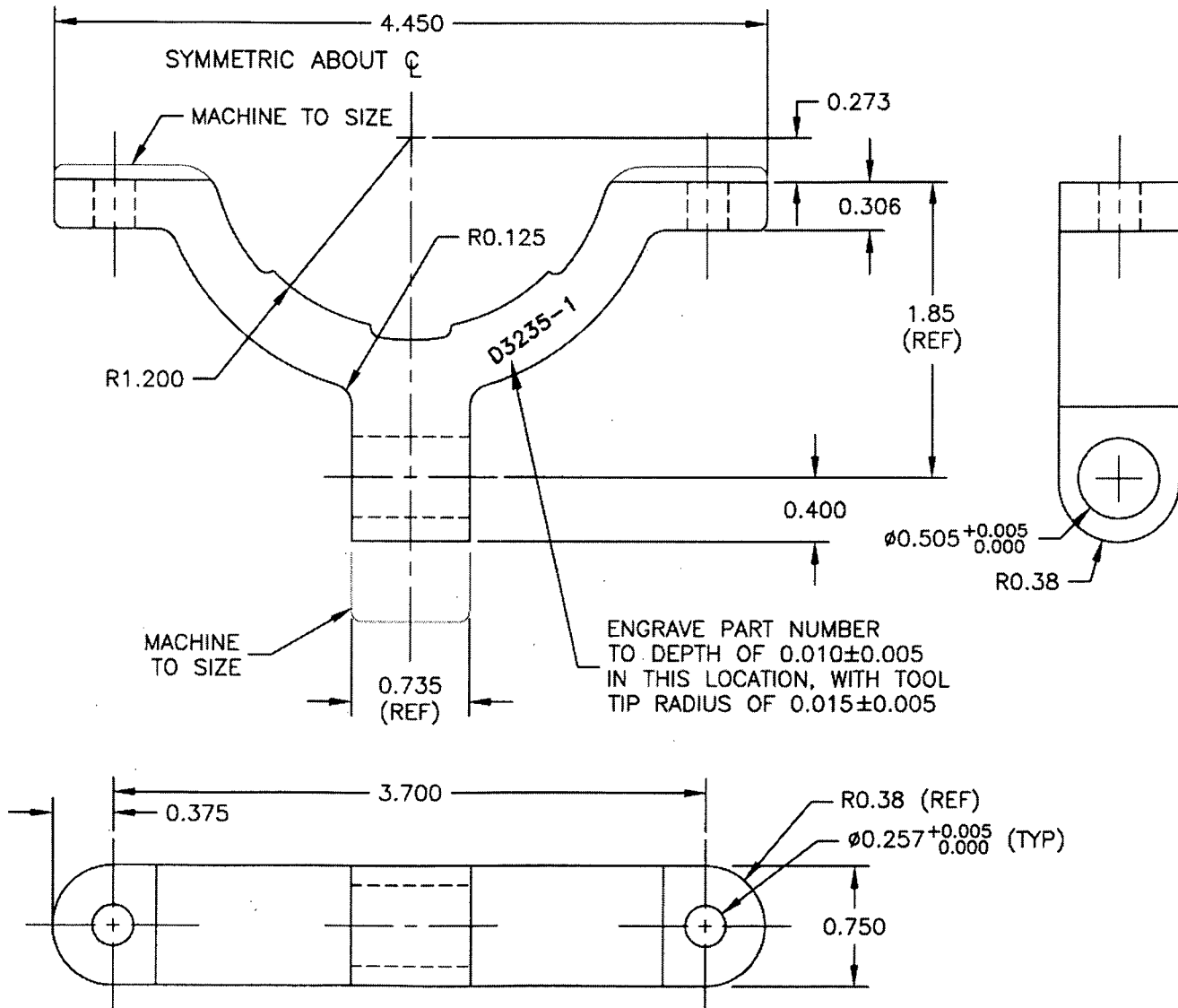
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	

DART

DESIGN 41	DRAWN BY 41	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED
040405 H

1054756

**D3235-1 MOUNTING LUG**

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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